

D212-805-011 POD MODIFICATION KIT
(COMPATIBLE WITH D212-601-041/-042 HELI-UTILITY-POD)
(RH INSTALLATION SHOWN, LH INSTALLATION OPPOSITE)

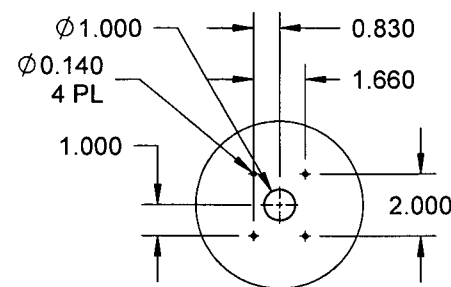
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 20 lbs APPROX
- 8) ENSURE D4175-041 WILL CLEAR D2200-1 LID FOAM CORE.
USE DT9667 CUTOUT TEMPLATE TO FASTEN/BOND D4175-041 TO D2200-1 LID.
REMOVE FASTENERS AND DT9667 TEMPLATE ONCE COMPLETELY CURED.
- 9) FOR INSTALLATION OF D4172-041 FRAME AND 80-005-3-8 INSERTS:
 - 9.1) LOCATE D4172-041 FRAME INSIDE POD SO THE FASTENER HOLES ARE MORE OR LESS ON THE CENTERLINE OF EACH D2200-3 POD RIBS;
 - 9.2) TRANSFER MARK AND DRILL SAME SIZE DIAMETER AS THE INSERT SHAFT DIAMETER TO A MAXIMUM OF 1.250" DEEP;
 - 9.3) CLEAN OUT FOAM CORE $\phi 0.125"$ TO $0.250"$ AROUND HOLE BETWEEN OUTER AND INNER SKINS;
 - 9.4) FOR EACH CAVITY, FILL ONE THIRD WITH "HYSOL EA394" OR EQUIVALENT EPOXY COMPOUND;
 - 9.5) INSTALL 80-005-3-8 INSERTS BY FILLING THE CAVITY WITH "HYSOL EA394" PER QSI 006 14.6 ENSURING INSIDE OF INSERTS ARE FREE OF POTTING COMPOUND;
 - 9.6) GRIND TO A SMOOTH SURFACE AS REQUIRED AFTER EPOXY HAS COMPLETELY CURED;
 - 9.7) TOUCH UP FINISH USING DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S.
- 10) TRANSFER DRILL HOLES IN POD AND D4177-1 DOUBLERS TO D3926-3 WEDGES PRIOR TO FASTENING D3926-3 TO POD.
- 11) SEAL EDGES OF ALL DRILLED HOLES AND CUTOUTS WITH CYANOACRYLATE GLUE (CRAZY GLUE)
- 12) WET INSTALL D3926-3, D4173-3/-7, D4174-1/-3, D4175-041, D4177-1 USING SIKAFLEX -241/-291 ADHESIVE
- 13) IT IS ACCEPTABLE TO USE LONGER AN4 BOLTS AND INSERT SHIMS AS REQUIRED BETWEEN THE POD RIBS AND D4172-041 FRAME.
MANUFACTURE 1.00" X 1.00" SHIMS TO REQUIRED THICKNESS FROM M6061T6S OR M6061T6B ALUMINUM.

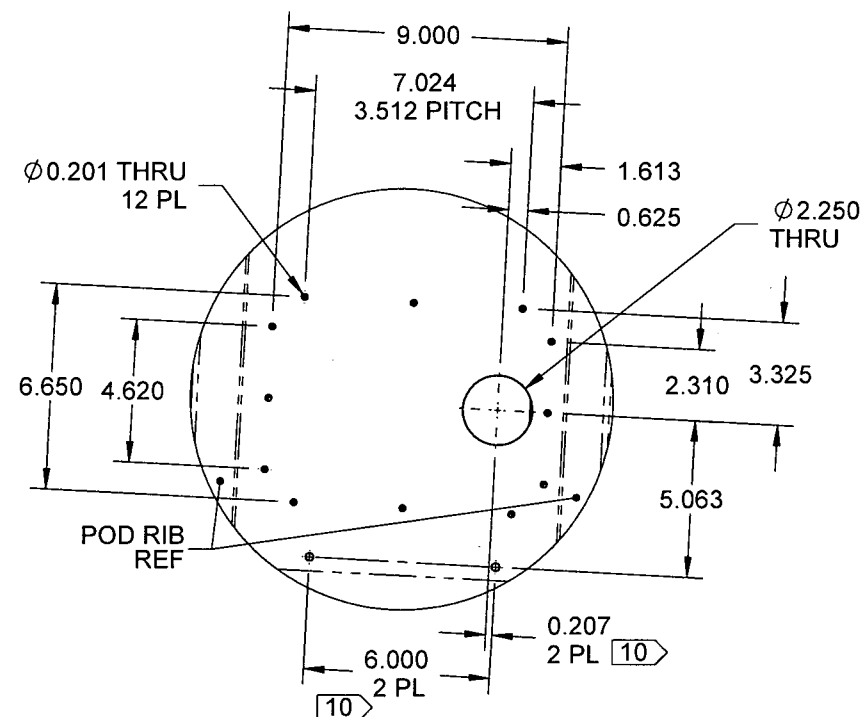
	ITEM	QTY. -011	P/N	DESCRIPTION
		X	D212-805-011	POD MODIFICATION KIT
12	1	2	D3926-3	WEDGE
	2	1	D4172-041	POD MOUNTING FRAME ASSY
	3	1	D4173-041	POD RADALT MOUNTING PLATE ASSY
12	4	1	D4173-3	POD RADALT DOUBLER
12	5	1	D4173-7	RADALT SHIM
	6	1	D4173-9	POD RADALT SEAL
12	7	1	D4174-1	CONNECTOR PLATE
12	8	1	D4174-3	CONNECTOR PLATE DOUBLER
8	9	1	D4175-041	POD GPS DOUBLER ASSY
12	10	2	D4177-1	RADALT GUARD DOUBLER
9	11	8	80-005-3-8	POTTED INSERT
	12	6	AN3-5A	BOLT
	13	4	AN3-6A	BOLT
	14	12	AN3-12A	BOLT
13	16	8	AN4-4A	BOLT
	17	22	MS21042L3	NUT
	18	12	NAS1149D0363J	WASHER
	19	32	NAS1149F0332P	WASHER
	20	8	NAS1149F0432P	WASHER
13	21	A/R	N/A	SHIM

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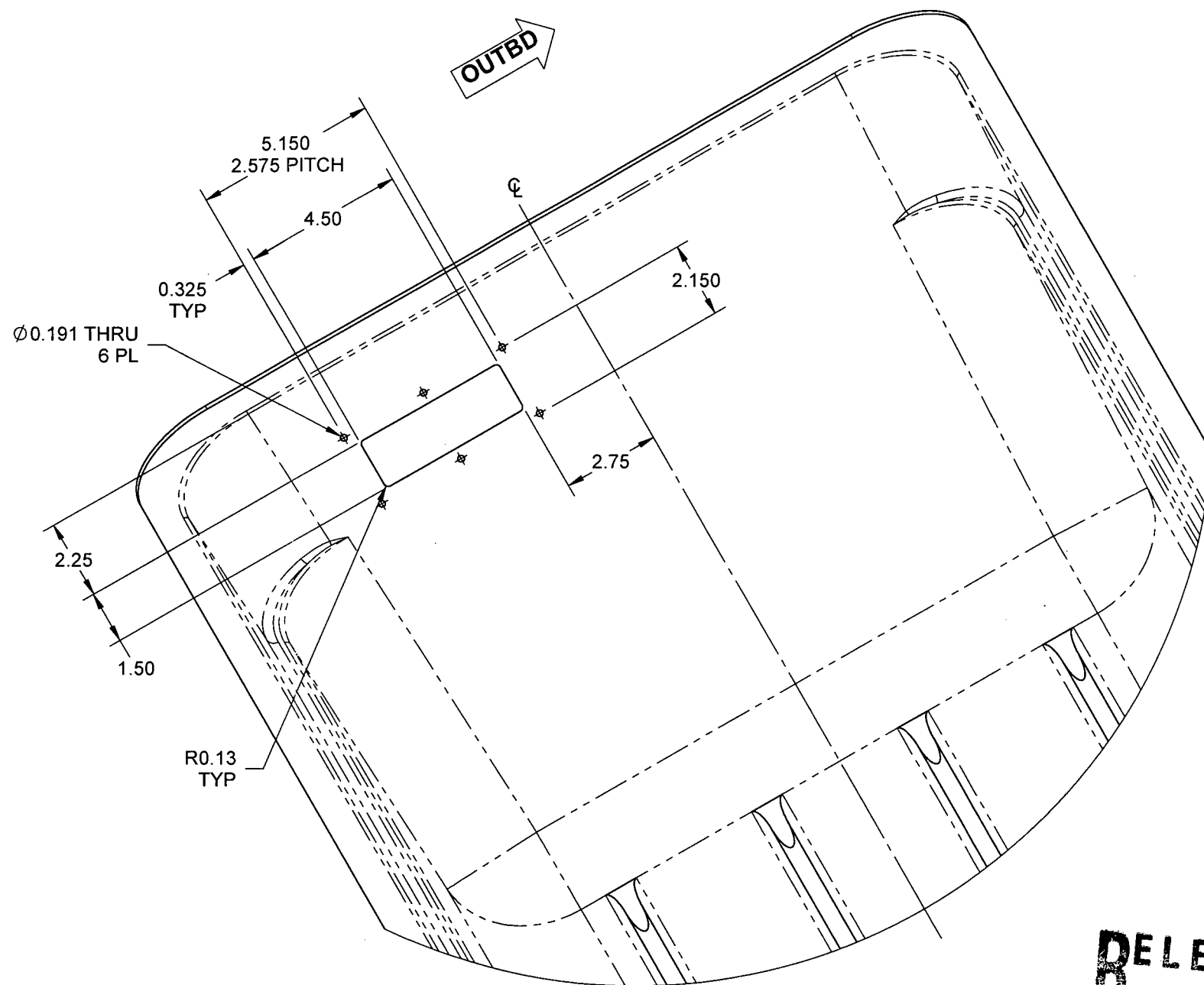
A	NEW ISSUE	MB	10.09.13
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DETAIL B: GPS MOUNT HOLE PATTERN D3-2
(TRANSFER DRILL HOLE PATTERN TO POD LID USING DT9667 TEMPLATE)
SCALE 2X 8



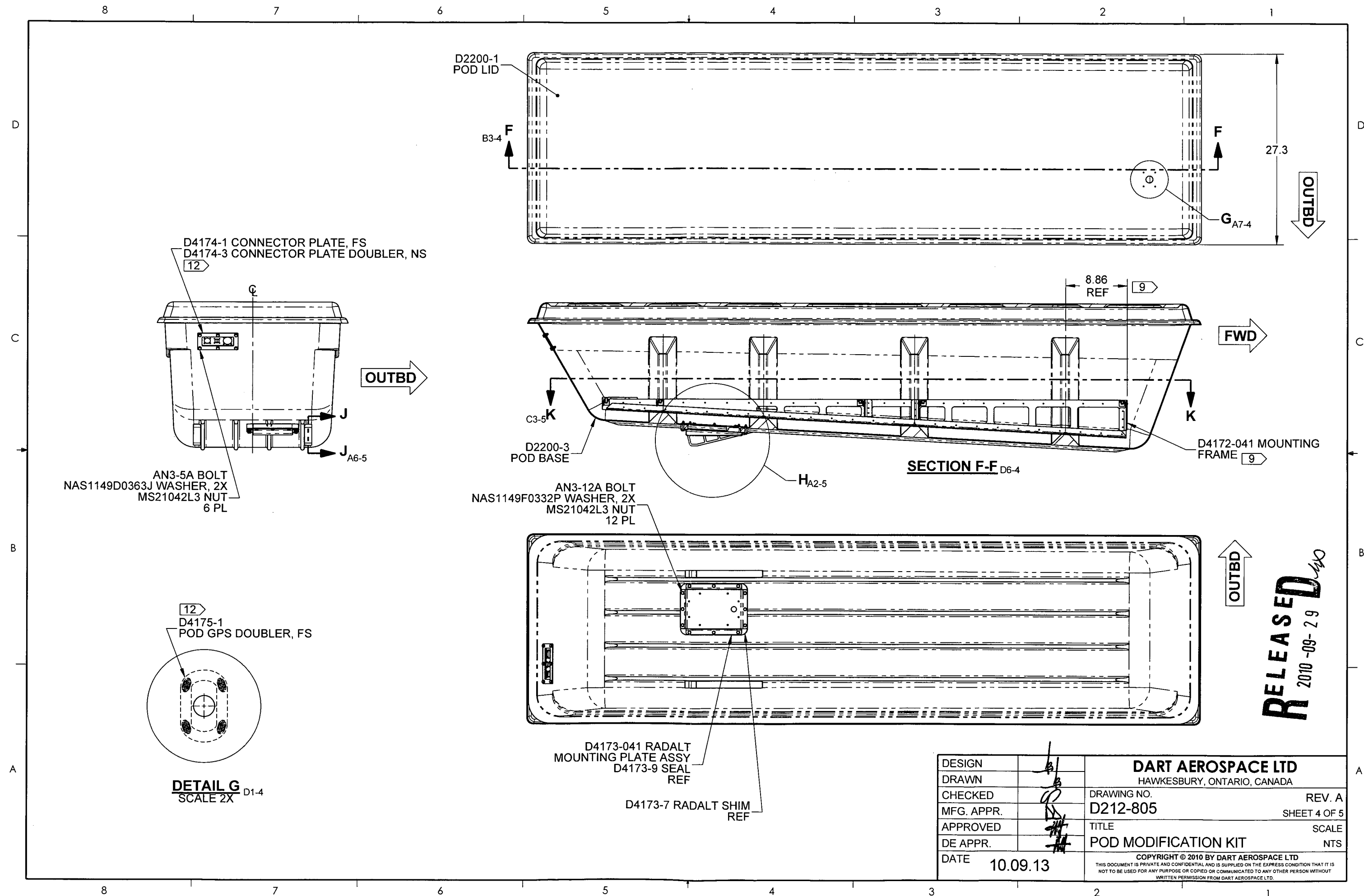
DETAIL D: RADALT MOUNTING PLATE HOLE PATTERN A7-2
(TRANSFER DRILL HOLE PATTERN TO POD BASE USING DT9669 TEMPLATE)
SCALE 2X 10



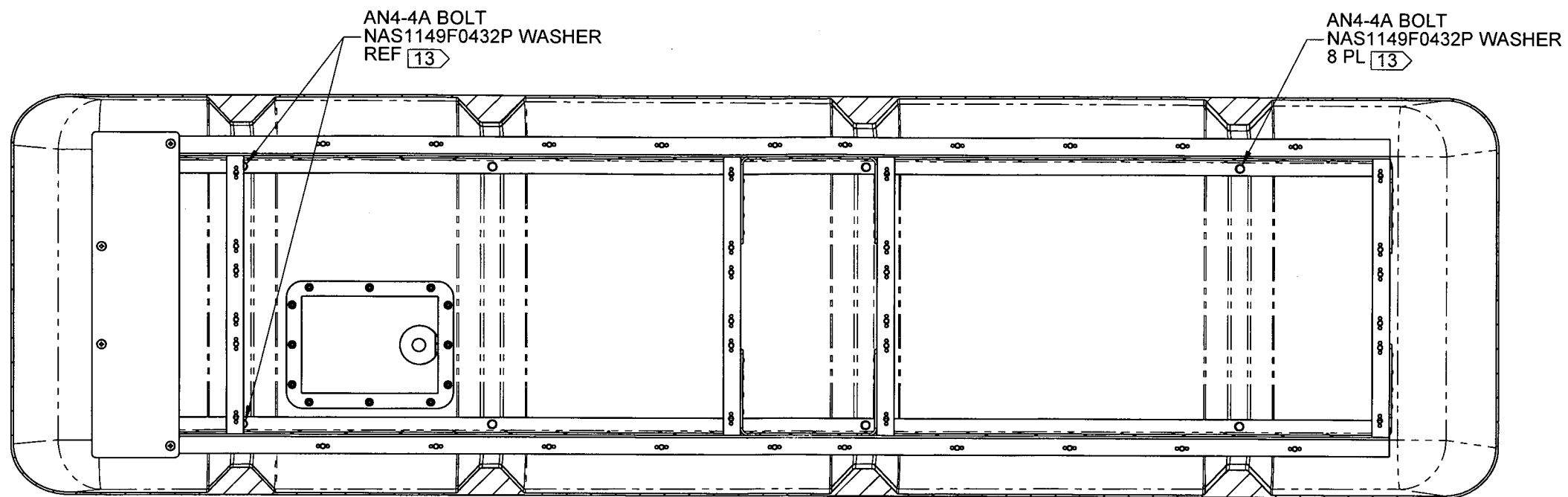
VIEW E-E: CONNECTOR PLATE HOLE PATTERN B7-2
(TRANSFER DRILL HOLE PATTERN TO POD BASE USING DT9668 TEMPLATE)
SCALE 3X

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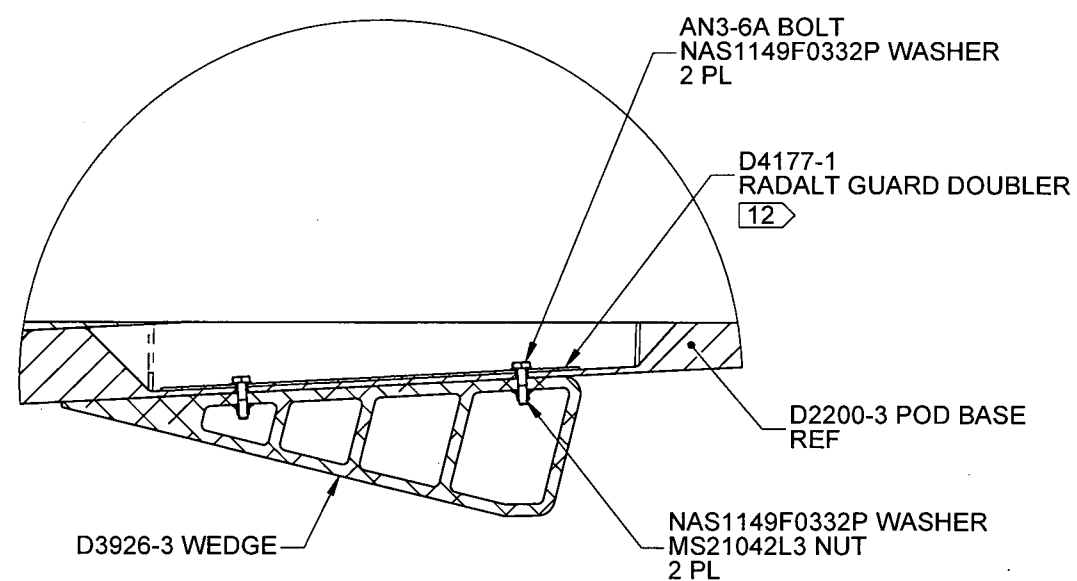
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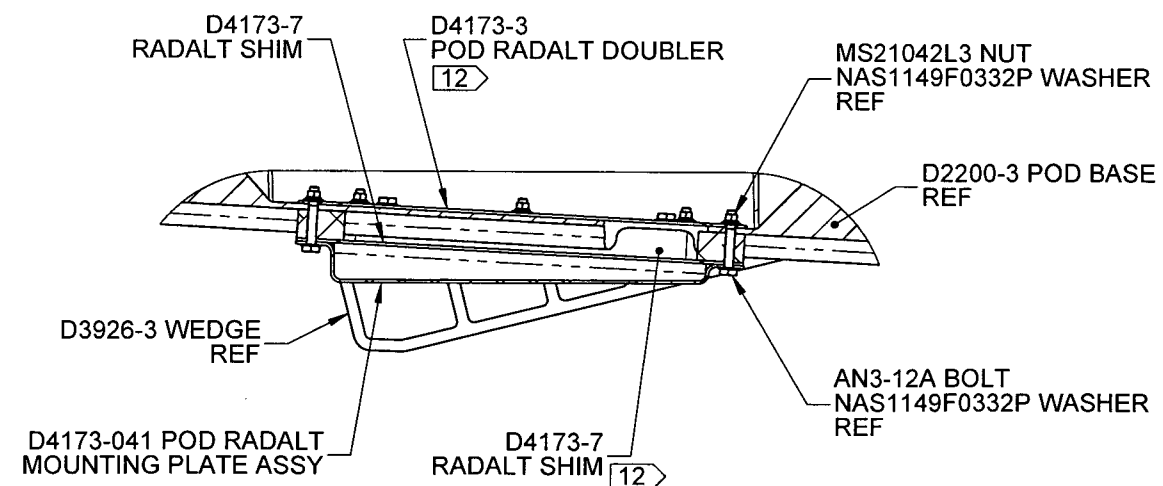
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SECTION K-K: D4172-041 POD FRAME INSTALLATION C5-4
SCALE 1.5X



SECTION J-J: RADALT GUARD INSTALLATION B7-4
SCALE 3X, 2 PL PER POD 10



DETAIL H: RADALT MOUNTING PLATE INSTALLATION B4-4
SCALE 3X

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